










~~OLD STYLE~~ *u*

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:17:25 AM  
User: Linda Lacelle

### Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b> : BRACKET ASSEMBLY	
<b>Job Number</b> : 28160			
<b>Estimate Number</b> : 11037			
<b>P.O. Number</b> : <i>N/A</i>		<b>Part Number</b> : D2804043	
<b>This Issue</b> : 15/08/2006 <b>S.O. No.</b> : <i>N/A</i>		<b>Drawing Number</b> : D2804 REV B	
<b>Prsht Rev.</b> : NC		<b>Project Number</b> : N/A	
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : R & D SM/MED FAB		<b>Drawing Revision</b> : B	
<b>Previous Run</b> : 26163		<b>Material</b> : <i>N/A</i>	
<b>Written By</b> : _____		<b>Due Date</b> : 08/09/2006 <b>Qty:</b> 8 <b>Um:</b> Each	
<b>Checked &amp; Approved By</b> : _____			
<b>Comment</b> : Est D 05.03.30 MS21043-3 was MS21042L3 KJ/JLM			
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	<i>X</i>
1.0	D28041	STA 155 Bracket	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit    Total : 8.0000 Each(s) STA 155 Bracket Pick: → Qty Part Number    Description    Batch 1    D2804-1    Bracket <i>B27615 smly C B28412</i>			
2.0	D28053	Stop	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit    Total : 8.0000 Each(s) Stop Pick: → Qty Part Number    Description    Batch 1    D2805-3    Stop <i>B28182 smly B25715 4mly</i>			
3.0	D2809	Bushing	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit    Total : 8.0000 Each(s) Bushing Pick: → Qty    Part Number    Description    Batch 1    D2809    Bushing <i>B27617 7mly AR 06/08/31</i>			
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Press D2805-3 into arm as per Dwg D2804 <i>mf. 06/09/13</i> <i>(8)</i>			

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 15/08/2006 7:17:26 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28160

Part Number: D2804043

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SR 06/09/13

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 09 18 (8)

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

G.M. 06-09-19

(8)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2804

MF 06/09/19 (8)  
~~06/09/13~~

9.0 AN3C16A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M10184 ✓ 15mx

~~M100218 1mx~~

AP 06/02/31

10.0 MS210433 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	M100218 1mx
			M19099 ✓ 15mx

MF 06/09/19

AP 06/02/31

11.0 NAS1515H3 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
			4 NAS1515H3

M100993 ✓

Washer

06/09/05 (7)  
AP 06/02/31 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/09/19	12	Applied LPS Hardcoat Corrosion Inhibitor m17045	MF. E	06/09/19 06.09.19	8		E 06.09.19

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/09/19  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/19	8	1 D2809 was scrap	MF. 06/09/19	Scrap + destroy replace it	MF. 06/09/19	E 06.09.19	MF. 06/09/19	E 06.09.19

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:17:26 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28160

Part Number: D2804043

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R

LPS-3

Corrosion Spray

ML01472

MF 06/07/19

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

MF 06/09/19 ⑧  
MF 06/09/19 ⑧

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/19 8

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

5/6/1 SB 06/09/19 ①  
SB 06/09/19 7

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/09/19 ①

Job Completion



u 06/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

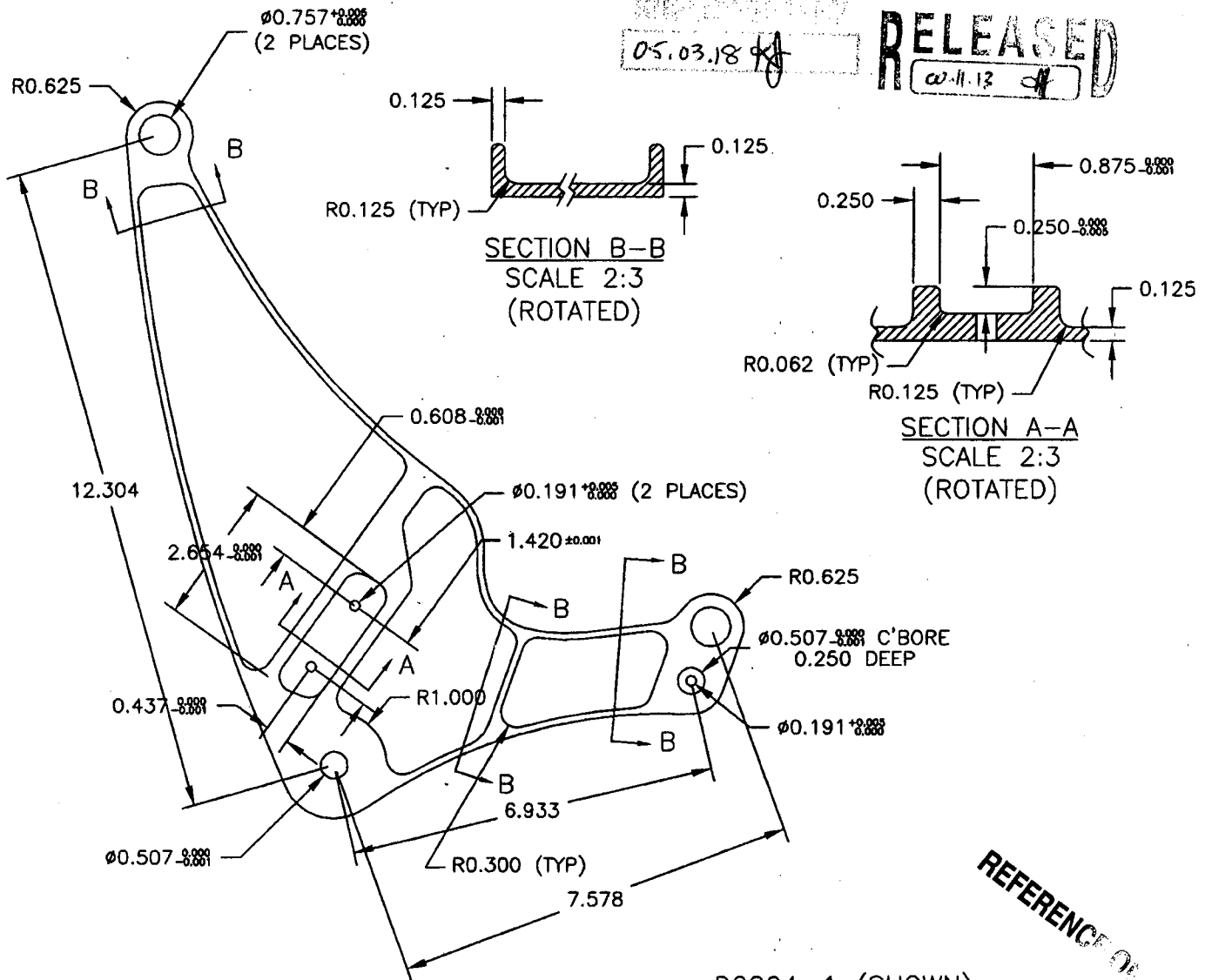
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 CP	



D2804-1 (SHOWN)  
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK  
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**DART**

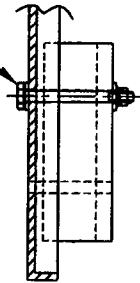
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3

RELEASED  
00.11.13

SUPERCEDED BY

05.03.18

AN3-16A BOLT (1)  
AN960JD10 WASHER (2)  
MS21042L3 NUT (1)  
(1 PLACE)



SECTION C-C  
SCALE 1:3  
(ROTATED)

USE D2804-1 FOR D2804-041 + -043  
USE D2804-2 FOR D2804-042 + -044

USE D2805-3 FOR D2804-043  
USE D2805-4 FOR D2804-044  
USE D2805-1 FOR D2804-041  
USE D2805-2 FOR D2804-042  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO  
POWDER COAT

REFERENCE

D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR  
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR



FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY  
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX  
(4.3.5.8) PER DART QSI 005 4.3

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